

# INSTALL INSTRUCTIONS FOR 03-09 GX470 APPROACH SERIES FRONT BUMPER

**READ THROUGHOUT BEFORE INSTALLING BUMPER!**

## **DETAILS:**

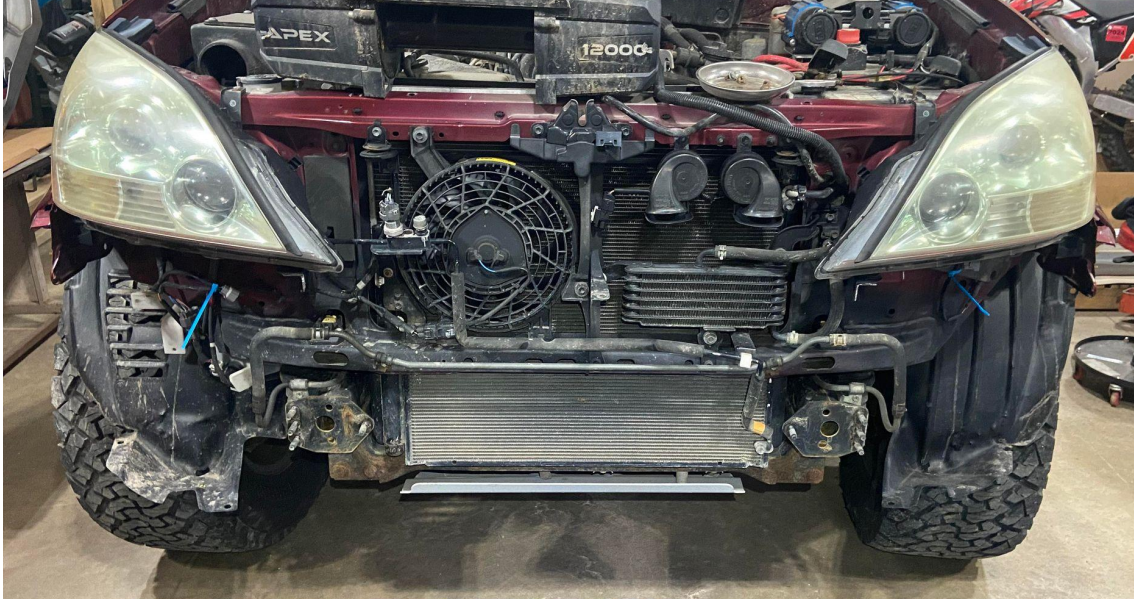
- Bumper will fit 03-09 GX470s, 03-09 4runners, and 05-15 Tacomas.
- Removal/cutting of factory bumper fender and center support brackets is required.
- Cutting of wheel well liner and bottom of fenders is required.
- Currently only designed for stock up to 1" body lift and suspension lifted vehicles. Having a body lift greater than 1" will result in a gap between the bumper and body.
- Plated and hybrid wing styles are interchangeable. If you would like to purchase just the wing set to change up the look of your rig, please reach out for a custom invoice.
- The bumper is only shipped as raw steel. There may be evidence of anti-spatter spray, oils, areas with light surface rust, small amounts of weld splatter, and shallow scratches caused during manufacturing and/or shipping.
- INTENDED FOR OFF-ROAD USE ONLY.
- Winch fitment info
  - The bumper was designed using the Harbor Freight Badlands Apex 12K with synthetic line WITHOUT needing to remove and remote mount the control box. Although it is still recommended to remote mount the control box to offer more clearance for the AC lines and added room to fit a cover over the winch when not being used.
  - Other similar sized or smaller winches may fit.
  - Must have a 4.5"x10" mounting pattern.
  - Depending on winch size you might have to relocate the control box and/or clock the winch drum.
  - Will NOT work with roller fairleads. Must be used with a hawse fairlead.

## WHAT'S INCLUDED:

- BUMPER PARTS
  - 1X CENTER WINCH CRADLE WELDMENT
  - 1X CENTER ALUMINUM COVER
  - 1X LEFT WING WELDMENT (HYBRID OR PLATED)
  - 1X RIGHT WING WELDMENT (HYBRID OR PLATED)
  - 2X GX470 ALUMINUM TOP FILLER PLATES
  - HARDWARE
    - 8X M8\*16MM FLANGED BUTTON HEAD BOLTS
    - 2X M6\*14MM FLANGED BUTTON HEAD BOLTS
    - 10X M12\*35MM YELLOW ZINC GRADE 8 FLANGED HEX BOLTS
    - 10X YELLOW ZINC GRADE 8 WASHERS (1.06 OD X .53 ID)
    - 10X M12 YELLOW ZINC GRADE 8 NYLON LOCKNUTS
    - 2X WASHERS (1.00 OD X .41 ID)
    - 8X M10 ZINC FLANGE NUTS
    - 2X ALUMINUM WASHER PLATE
    - 2X M8\*20MM FLANGED HEX HEAD BOLTS
    - 2X WASHERS (.69 OD X .34 ID)
    - 2X M8 NYLON LOCKNUTS
    - 4X M6\*12MM BUTTON HEAD BOLTS
    - 4X M6 NYLON LOCKNUTS
  
- (OPTIONAL) MINI SKID
  - MINI SKID WELDMENT
  - HARDWARE
    - 3X M8\*20MM FLANGED HEX HEAD BOLTS
    - 3X WASHERS (.69 OD X .34 ID)
    - 3X M8 NYLON LOCKNUTS
  
- (OPTIONAL) FRAME BRACKETS
  - 1X LEFT FRAME BRACKET
  - 1X RIGHT FRAME BRACKET
  - HARDWARE
    - 2X M12\*30MM HEX HEAD BOLTS
    - 2X WASHERS (1.06 OD X .53 ID)
    - 2X M8\*20MM FLANGED HEX HEAD BOLTS
    - 2X WASHERS (.69 OD X .34 ID)
    - 4X M10\*35MM FLANGED HEX HEAD BOLTS
    - 4X WASHERS (1.00 OD X .41 ID)
    - 4X M10 NYLON LOCKNUTS
  
- (OPTIONAL) HEADLIGHT FILLERS
  - 1X LEFT FILLER
  - 1X RIGHT FILLER
  - 5FT DOUBLE SIDED VHB TAPE

## MODIFICATIONS TO VEHICLE:

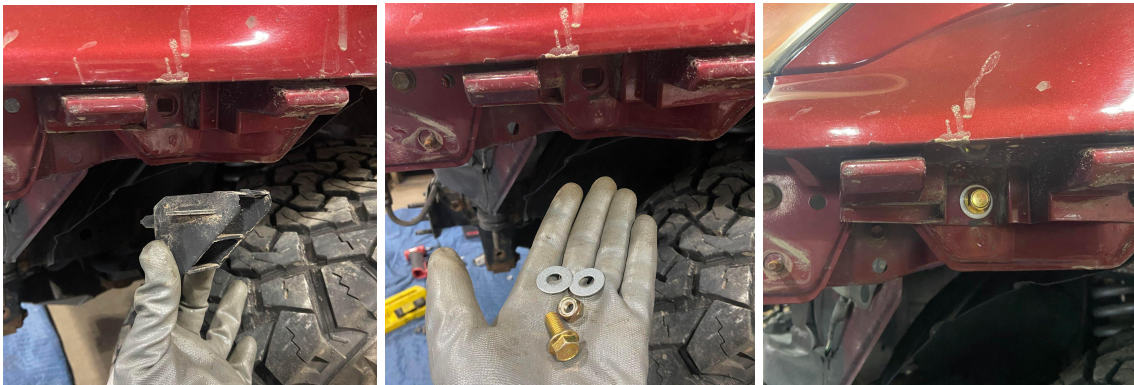
- 1) Remove the stock bumper, fog lights, crash bar, and any bolt on brackets that held the plastic bumper cover.



- 2) Cut back brackets under headlights on both sides. Deburr sharp edges.



- 3) Remove plastic clip and replace with a M8\*20MM bolt, washers, and locknut.

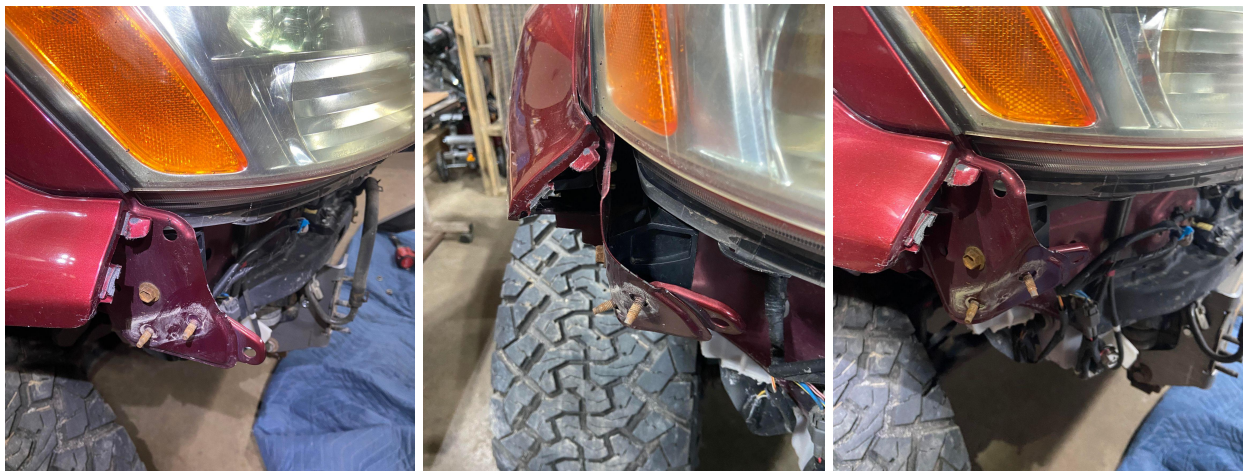




4) Cut the mounting tabs off the underside of the fenders.



5) Cut off or bend in tabs on the front of both bumper brackets on the fenders.



6) Remove or cut back the bracket that sticks out near the center of the radiator. Can either trim it back or drill out the spot welds and remove it completely. If drilling out welds, be careful to not slip and damage the radiator. (Shown with it drilled out)

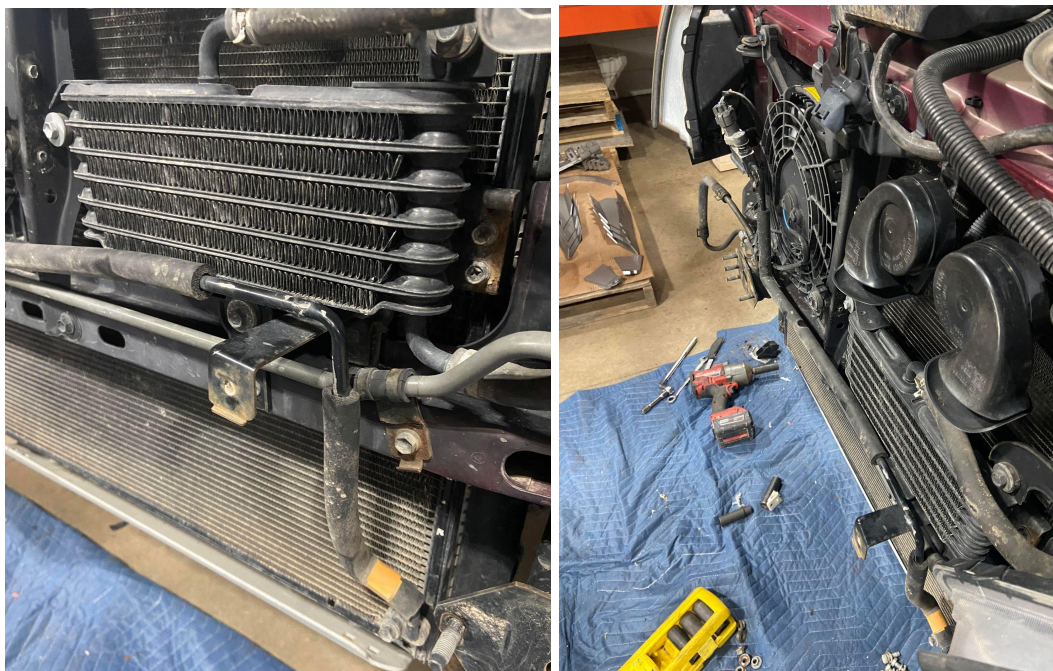




- 7) Cut wheel well liners. Using a sharpie or masking tape, mark a line going from the corner of the fender flare down to bottom of the liner that's closest to the truck frame. Ensure there are no wires directly behind your marked line. CAREFULLY cut along the line with a sharp box cutter. If desired, can drill a couple holes through the lower edge of the sheetmetal and plastic liner and zip tie them together.

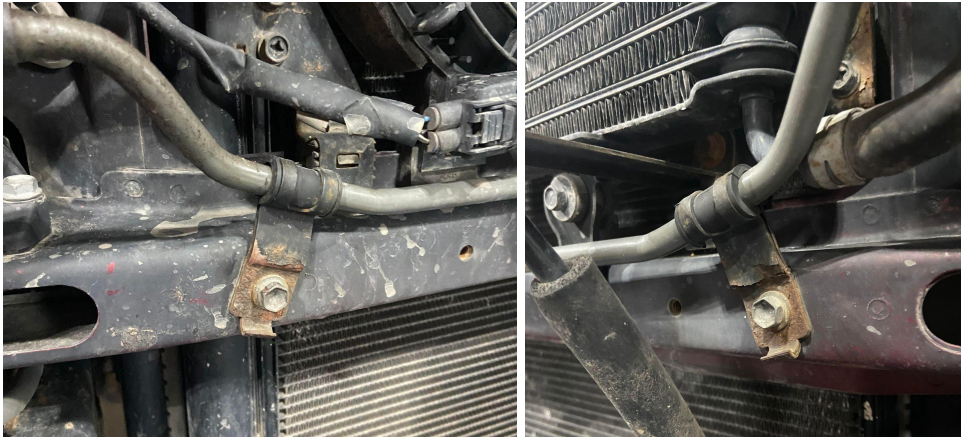


- 8) (OPTIONAL) If running a winch perform the following.
- Remove the AC line from the bracket and position the line inward towards the radiator. Can leave the bracket or remove/cut it off if you want additional room.





b) Bend the trans line tabs up and inwards towards the radiator.



c) Using a punch and/or hammer, CAREFULLY flatten out the edge protruding from the center vertical brace to make additional room for the AC/trans lines to tuck in.



9) CAREFULLY trim tabs off washer fluid reservoir.



10) Recommended to clean any cut or hammered areas and coat with spray paint to prevent rust from forming.



## VEHICLE INSTALL:

**\*Some pictures may be from 4th gen 4runner, but it is the same process for the GX470.**

- 1) Read through entire instructions.
- 2) Ensure all parts and hardware are accounted for.
- 3) All raw steel parts should be painted/powdercoated prior to install for rust protection.
- 4) Complete all modifications to the vehicle listed above.
- 5) (OPTIONAL) Install headlight fillers. (can be done after bumper wing install but is much easier to do before)
  - a) (OPTIONAL) Buff, prime, and paint the fillers to match your vehicle's body.
  - b) Trim the larger outer tab off the ends of the fender flares.



- c) Clean the underside of the headlights so they are free of dirt and grease.
- d) Apply double sided tape to the top flange of the headlight fillers. It should be slightly in-set from the outer face/edge. Leave the plastic cover on the tape and firmly push it down to adhere to the flange of the filler. Then remove the plastic cover.



- e) Align the filler under the headlight.



- f) Hold the filler at a slight angle so the tape isn't touching anything yet and line it up to the end of the fender flare.
- g) Gently press up so the tape only contacts the underside of the headlight near the end of the fender flare.
- h) Work your way around from the end flare to the center of the vehicle. Be sure to keep the same spacing and to not let the filler sit too far inward or outward.



- i) Once it's in the correct position, firmly press against the bottom side of flange to fully adhere the tape to both the fillers and the headlights.



- 6) (OPTIONAL) Install frame brackets.
  - a) If you have a V8 with trans cooler lines, remove the M8 bolts attaching the trans line brackets from the outer side of the frame rails.
  - b) Loosen the M8 bolt that holds the trans line to the top of the driver side frame rail. (Access through the wheel well) Spray a little wd40 on the clamp and push the line through by a couple inches. Retighten the bolt.





- c) Remove the M8 bolt that holds the line to the top of the passenger side frame rail. Bolt is no longer needed and can be discarded. Leave the trans line free hanging, it's fine.
- d) Lift up on the trans line brackets to move them out of the way.
- e) Install the frame brackets so the tabs are pointing inward.
- f) Reposition the trans line brackets so they are over the frame brackets.
- g) Take the M12 bolt with large washer and install it into the lower threaded hole. Leave it somewhat loose.
- h) Take the M8 bolt with smaller washer and install it into the upper threaded hole sandwiching the trans line bracket. Leave it somewhat loose.



7) (OPTIONAL) Install mini skid.

- a) Take the mini skid and line it up with the holes on the bottom of the winch cradle. It's MUCH easier to install while off the vehicle.
- b) Take the 3X M8 bolts and pass them through the aligned holes.
- c) Take the 3X washers and locknuts and install on the backside of the bolts. Leave them somewhat loose for now.



8) Install center winch cradle.

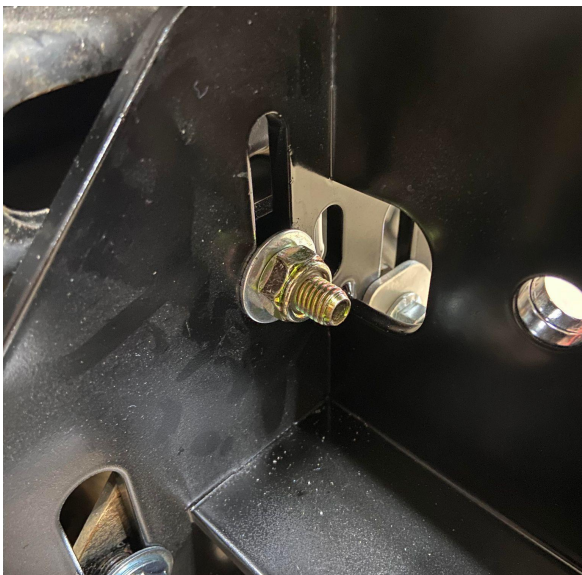
- a) Take the center winch cradle and install over the studs on the ends of the frame rails.
- b) Take the aluminum washer plates and install over the outer studs followed by the provided M10 flanged nuts. Leave somewhat loose for now.



- c) Take the 1" OD washer and install over the inner studs followed by the M10 flange nuts. Leave somewhat loose for now.



- d) (OPTIONAL) If running the frame brackets, take the 4X M10 bolts and pass them through the aligned slots. Install the washers and locknuts on the backside. Leave somewhat loose for now.





- 9) Install side wings.
  - a) If running lights, it's highly recommended to install on the wings prior to putting the wings on the bumper.
  - b) Align the wings to the sides of the winch cradle. It's helpful to either have a second set of hands or to use a clamp to hold them together.
  - c) Take the flanged M12 bolts and install them through the aligned holes.
  - d) Install washers and locknuts on the back sides of the bolts. Leave somewhat loose for now.
  - e) If running the hybrid wings, the ends of both tubes have an internal weldnut. Install a M12 bolt into both of those. Leave somewhat loose for now.



10) Adjust the bumper.

- a) You can raise/lower the bumper on the mounting slots. Once its at your preferred height, tighten down the nuts on the mounting studs.
- b) If offroading where you will experience lots of body on frame flex/movement. It is recommended to leave a 1/4" to 1/2" gap between the wings of the bumper and the underside of your fenders and headlights.
- c) There is a little adjustability in the rotation of the wing. Position them how you want and tighten down the nuts/bolts.
- d) If necessary, you can also add washers between the wings and the sides of the winch cradle to act as shims and further adjust the position of the wings.



- e) If you are having contact between the lower fender brackets and wings or they are pretty close, put a large flathead screwdriver/prybar between them and bend in the fender brackets for extra clearance.





- 11) (OPTIONAL) Tighten hardware for the frame brackets.
- 12) (OPTIONAL) Adjust height of mini skid to preferred location and tighten the hardware.
- 13) (OPTIONAL) If running a winch, it is recommended to install it at this point.
- 14) Install aluminum cover.
  - a) Align the slots on the cover over threaded holes on the lower front of the bumper.
  - b) Take the 8X M8 flanged head bolts and install them into the threaded holes and tighten down.



- 15) If your state requires a front license plate, install it centered on the aluminum skid using the 2X M6 flanged head bolts. You will need to bend the plate forward to make it actually visible. Do NOT overtighten bolts!
- 16) (OPTIONAL) Install center lightbar.
- 17) Wire lights.
  - a) Sorry no detailed instructions for this step as there are too many different ways to do it. But contact us if you are having trouble and we'd be happy to help or provide resources.
- 18) Install top aluminum filler plates using the M6\*12mm bolts and locknuts.



- 19) Enjoy your new bumper and send us cool pictures!